0.00

Memo

QC

Quality Control

NCR: Y	es / No				WORK ORDER NON-	CONFC	ORMANCE / UF	PDATE	QA Closed:	Date:		
Work Orde Part N NCR N	lo.				DISPOSITION Rework Scrap Use-as-is Work Order Update	Th	Skid-tube Machining Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Engineering Prod. Eng. Coor. Quality Rec/Store/Packaging Supplier			
Root	Dete	Chan	Otto	13134344444	iption of work order update	Initia	50	ction	Sign & Date	Verification	QC Inspector	
Cause	Date	Step	Qty		or Non-conformance	Chief I	ng Des	cription	Date	verincation	QC Inspector	
Doc/Data Equip/Tooling Operator Material Setup Other												
Process						The same						
Supplier						13			A. A.		West 1	
Training										THE RESERVE		
Unapproved	She d								1.4.2			
***************************************	Jan 1997					AULT C	ATEGORY					
Landi	ng Gear			_	General	\Box	2.	- 21	12			
	Bending			0/0	Bend	Gra			Ovalized Over/Under	-	Pressure/Forced	
10 53	-	lot Conce	ntric to	0/5	BOM/Route	\vdash	dware	- 50	Part Incorre		Temperature/Cure Weld	
	Cracks	/Crimped		-	Broken/Damaged Burrs		pection incomplete tructions incomplete	/Unclear	Part Lost/M		Wrang Stock Pulled	
	Cuffs	Cimped		-	Contamination		intenance	J Official	Part Moved	Jane	Junion Stock Funed	
The state of the s	Heat Tre	at			Countersink		labeled	91	Positioned V	Vrong		
			Tube		Cut Too Short	-	read		Power Loss/		Other	
	Inspection Strip in Tube Ripples in Bend				Drill Holes	Off		1		MARK THE STATE OF		
		Waves in	Extrusio	n	Drawing		t of Calibration					
		Sequence			Finish	Ou	t of Sequence		Tale	A TOTAL PROPERTY.	transfer and the	

Outside Dimensions

DQA:

Date:

Wave/Twist in Tube

Folio

Work Order ID 102280

102280

Page 2

May-27-13 12:42:48 PM

Item ID:

D2230-1

Accept

N900040100

Setup Start

Revision ID: Item Name:

Start Date:

Lug

6/03/13

Start Qty: 220.00 Req'd Qty: 220.00

Cust Item ID: Customer:

Reference:

Approvals: Process Plan: Date: Date: Tooling:

Date:

Run

QC:

Required Date: 6/03/13

SPC (Y/N):

Date:

Qty

Sequence ID/ Work Center ID

140

HandFinish Hand Finishing Operation Description

Chemical Conversion Coat per QSI005 4.1

Set Up/ Run Hours

0.00

Tool ID

Tool # Plan Code

Qty

Accept

Reject Reject

Number Stamp

134 26/3-7-4

150

140

150

QC Quality Contro QC3-Inspect Part Finish

Memo

Memo

0.00

0.00

0.00

134x pm-f 13/07/08

160

160

Powdercoat Powder Coating White Gloss(Ref:4,3.5.1) per QS1005 4,3-Alum

0.00

OVEN TEMPERATURE:

FINISH TIME:

134X8mf 13/57/08

M125620

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA:	Date:	4 3

QA	Clo	se	d:

Date:

Work Order					DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
work order					Rework			Skid-tube	Crosstube		Water Jet	Engineering
Part No).				Scrap		- 1	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is		Thern	noforming	Finishing	Rec/Stor	re/Packaging	Other
NCR No	o				Work Order Update			Large Fab	Composite		Supplier	
	_	,										
Root					ption of work order update		nitial		tion	Sign &	V:6	
Cause	Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data							,					
Equip/Tooling Operator									-			
Material	-											
Setup									- 1		MARKET STATE	
Other					15.2							
Process	7											
Supplier	7	4.										
Training												
Unapproved												
St. Land					FAULT CATEGORY							
Landin	g Gear			_	General		N.					
	Bending	li .			Bend		Grain		4.7	Ovalized	pue la	Pressure/Forced
Bi - 24	Centre	Not Conce	ntric to	O/S	BOM/Route		Hardwa	re		Over/Under	CONTRACTOR OF THE PARTY OF THE	Temperature/Cure
1	Cracks				Broken/Damaged		ACCUMENTATION OF THE	on Incomplete		Part Incorre	_	Weld
	17 A P. A CO.	I/Crimped			Burrs		-	ions Incomplete/	'Unclear	Part Lo实/Mi	ssing	Wrong Stock Pulled
	Cuffs			_	Contamination		Mainte			Part Moved		10
	Heat Tr		-		Countersink		Mislabe			Positioned V		Talle
Inspection Strip in Tube				Cut Too Short		Misread	1		Power Loss/	Surge	Other	
Ripples in Bend			Drill Holes		Offset					A REPORT AND		
Torque Waves in Extrusion			Drawing		-	Calibration						
18 m	Turning Sequence Wave/Twist in Tube				Finish		-	Sequence				
THE N	wave/	wist in Tu	be		Folio		Outside	Dimensions		the the state of		43

Work Ord May-27-13 12:		02280		*102	2280*							Page	3
Item ID: Revision ID: Item Name: Start Date:	D2230-1 Lug 6/03/13	Start Qty: 220.00	*220*	Accept	*N900		100)*	Setup	Start Stop		S1* S2*	
Required Date: Reference:	: 6/03/13	Req'd Qty: 220.00	*220*		Customer:								
Approvals:	Process I		ate:	Tooling:		ate:			Run	Start Stop	*N	R1*	
	QC:	D	ate:	SPC (Y/N):	Date:					этор	*N	*NR2*	
Sequence ID/ Work Center II 170 *170*	D	Operation Description QC3- Inspect Part Finish		Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accept Qty	Qty	1	Reject Number	Insp. Stamp	
QC Quality Control		Мето		0.00				131	1 1	4	λų	13	09
180		Identify as per dwg & Stock L	ocation: ST 46	0.00				2 (
Packaging Packaging		Memo		0.00				134x	bar	Emil	ie.	13-7)
*190		QC21- Final Inspection - Work	Order Release	0.06					13	171	11 0	A	
QC Quality Control		Мето		0.00					1,	111			
											B-07	()	
										4			

U	CR	V	25	/	No
w		1.3	-3		NO

WORK ORDER NON-CONFORMANCE / UPDATE

DQA:	Date:	4
T DESCRIPTION		

										QA Cli	osed:	Date:	The Late	
Vork Order	r:				DISPOSITION				AGAINST D	EPARTN	IENT/	PROCESS		
Part No					Rework Scrap			Skid-tube Machining	Crosstube Small Fab		Piror	Water Jet	Engineer	ring
NCR No					Use-as-is Work Order Update		Therm	noforming Large Fab	Finishing Composite	MARKET NO.		e/Packaging Supplier		her
Root	R			Descri	ption of work order update		nitial	Ac	ction	Sign	&		1	
Cause	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	cription	Da	te:	Verification	QC Ins	pector
oc/Data											4			
quip/Tool ng	_													
perator		1				P				3.00				
Material	-						y i			Frank.			135	
etup	_		1							* 4				
ther	-	1 -											i i	
rocess	-									The Late				
upplier	-	N.								- FIG			Tani Sas	
raining napproved	-									11 134				
mapproved		1	1		-	AUI	T CATE	GORY		75.				
Landin	g Gear				General					1.64			The second	W. J.
	Bending				Bend		Grain		Г	Ovaliz	ed		Pressure/F	orced
	Centre N	lot Conce	ntric to	O/S	BOM/Route		Hardwa	re	- 171	Over/I	Jnder	tolerance	Tem peratu	re/Cure
	Cracks				Broken/Damaged		Inspect	on Incomplete		Part In	Опес	t	Weld	
	Crushed	/Crimped			Burrs		Instruct	ons Incomplete/	/Unclear	Part Lo	st/Mi	ssing	Wrong Sto	ck Pulled
	Cuffs				Contamination		Mainte	nance	14.	Part M	loved			
97. 1 10	Heat Tre	at			Countersink		Mislabe	led		Positio	ned W	/rong		
1 1	Inspection	on Strip ir	Tube		Cut Too Short		Misread	1		Power	Loss/S	Surge	Other	715
F4. 4.	Ripples i	n Bend			Drill Holes		Offset			- 172			THE	3.5

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

Picklist Print

May-27-13 12:42:48 PM

Work Order ID:

102280

Parent Item:

D2230-1

Parent Item Name:

Lug

Start Date: 6/03/13

Required Date: 6/03/13

Page 1

Start Qty: 220.00

Required Qty: 220.00

Comments:	IPP D00.11.01A	dded inspection	level 8, and	removed P/O	for powder coa	tEC							
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status

D2230-1P LUG

D2423

Lug Extrusion

Manufactured No

Purchased

No

110

Each

566.7400

0.0000

0.0683

Location Loc Qty Loc Code MAT006 383 43722 161.5 87953 221.5 Metec 183.74 93551 183.74

5.82

N	CR:	Yes	/ No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA:	Date:		í
	表面 EN 文 LE		
		(III No.	1

	QA Closed: Date:																
Work Order	r:					DISPOSITION				AGAINST D	ST DEPARTMENT/PROCESS						
TOTAL OTTO						Rework		Skid-tube Crosstube					Water Jet	Engineering			
Part N	0.					Scrap	300	Machining Small Fab				Pro	d. Eng. Coor.	Quality			
	-					Use-as-is						re/Packaging	Other				
NCR N	0.					Work Order Update		Large Fab Composite Supplier									
							TOTAL STATE OF THE										
Root	1				Descri	ption of work order update	- Ir	nitial	100	Action	Sig	n &					
Cause	1	Date	Step	Qty	(or Non-conformance	Chi	ef Eng	De	escription	D	ate	Verification	QC Inspector			
Doc/Data		2.					200				# 4			16#			
Equip/Tooling							Shr.					17 E					
Operator							YP.						ALL DES				
Material							100				1.5						
Setup							-										
Other							Sales				F *						
Process									노랑					Venet 1			
Supplier											100						
Training							CEV.										
Unapproved						tild i film							Hillian of				
E.v.							AUL	T CATE	GORY								
Landin	_				_	General				_	7		_				
		Bending				Bend	\vdash	Grain		-	Ovali			Pressure/Forced			
1 - L	_	Centre No	t Concer	ntric to	o/s	BOM/Route	\vdash	Hardwa			333		tolerance	Temperature/Cure			
		Cracks				Broken/Damaged		A CONTRACTOR OF THE PARTY OF TH	ion Incomplete	-		ncorre		Weld			
	_	Crushed/C	Crimped			Burrs	-		ions Incomplet	te/Unclear		Lost/M		Wrong Stock Pulled			
ii i		Cuffs				Contamination	\vdash	Mainte			- PROPERTY OF THE PARTY OF THE	Moved					
		Heat Treat				Countersink	\vdash	Mislabe			100	ioned \					
8.	Inspection Strip in Tube					Cut Too Short	\vdash	Misrea	1	[Powe	er Loss/	Surge	Other			
Ripples in Bend					Drill Holes		Offset			91							
	Torque Waves in Extrusion				n	Drawing	Out of Calibration										
						Finish	Out of Sequence										
Wave/Twist in Tube Folio								Outside	Dimensions		- 9						

D2230-1

D2230-1 MOUNTING LUG



102280MG 13-05-27

D2230-3 MOUNTING LUG



DESIGN	SN BW DART AFROCE	ACEL	**
REV	DESCRIPTION		DATE
С	RE-DESIGN		94.03.30
D	RE-DESIGN		95.01.04
E	RE-DESIGN		95,01.04
F	REGESIGN; R1 200 WAS 1 100		99.12.12
G	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS, REFER TO SECTION A-A & B-B FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION	AJS	09.01.16

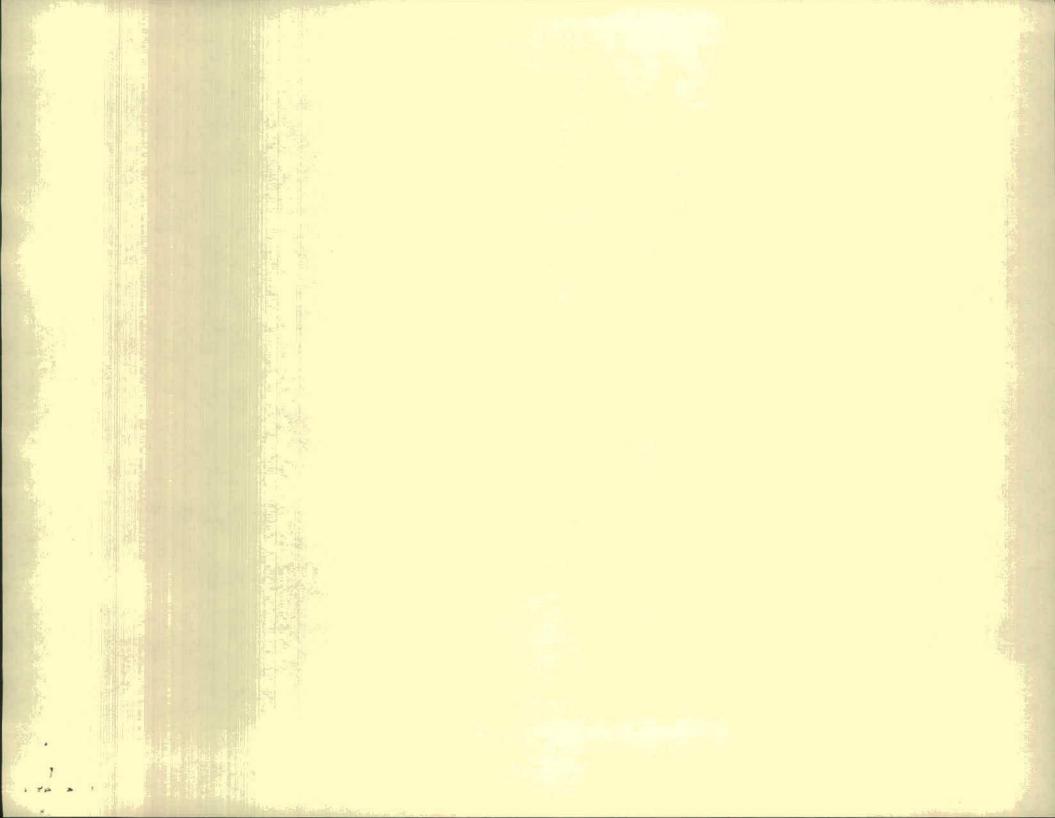
DART AEROSPACE LTD DRAWN AJS HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. G D2230 MFG. APPR SHEET 1 OF 3 APPROVED SCALE MOUNTING LUG DE APPR NTS COPYRIGHT (0 1994 BY DART AEROSPACE LTD.
THE DOCUMENT IS REWARD AND CONCIDENCE, AND IS SUPPLIED ON THE EXPRESS CONCIDENCE.
MOT TO BE URED FOR ANY PURPOSE OF COMPLIANCE OF ANY OTHER PERSON
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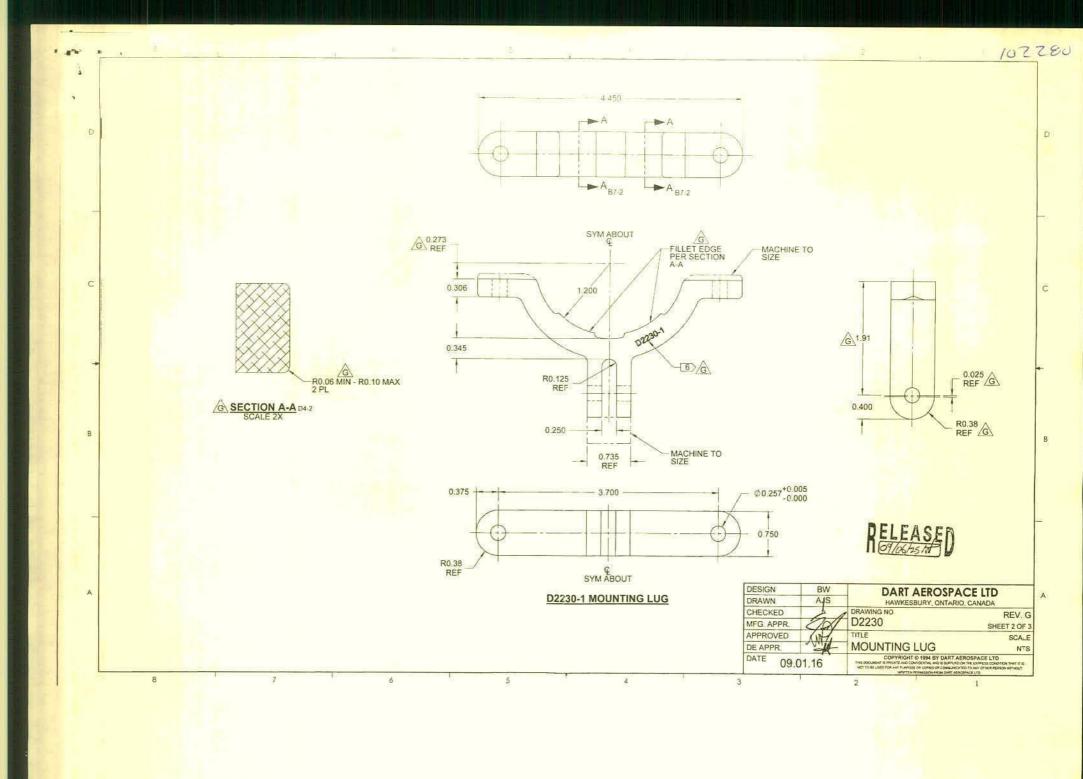
G

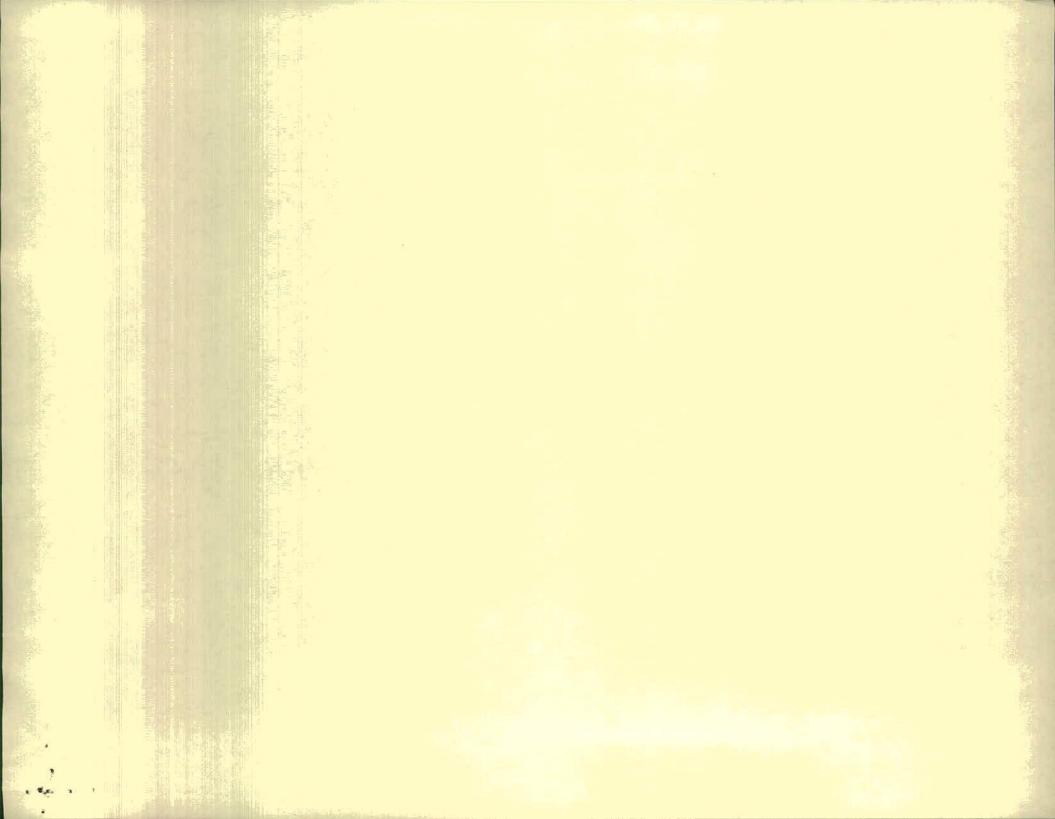
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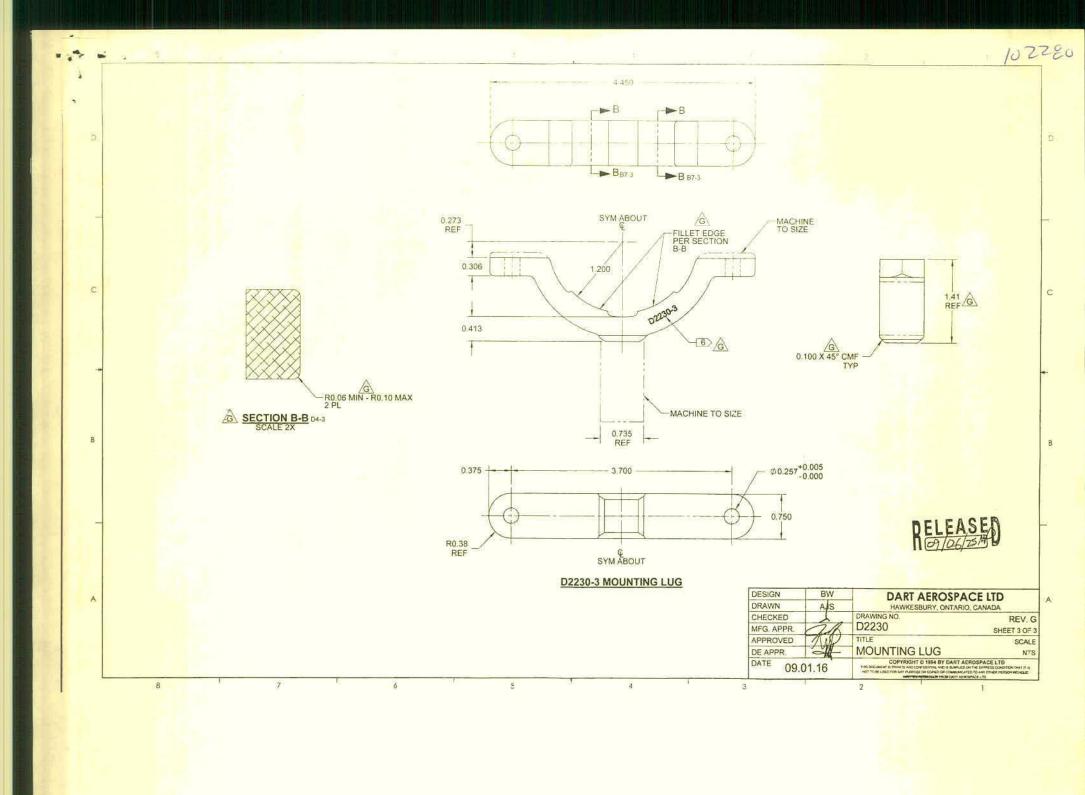
C

NOTES
1) MATERIAL: MAKE FROM D2423 EXTRUSION
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT-WHITE (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ±0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015 ±0.005.
7) WEIGHT: -1: 0.16 lbs
-3: 0.14 lbs













20 Terry Fox Drive Vankleek Hill, Ontario K0B 1R0, Canada Tel: (613) 678-3957 Fax: (613) 678-3956

Delivery Slip No.:

19082

Date:

Jun 26, 2013

Page:

1

Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7		Ship to:		
		Att. 127	rt Aerospace Ltd. Linda Lacelle 70 Aberdeen Street wkesbury, Ontario K6A 1K7	
Order No.:	20001	Sold By:	Dewar, Eric	
Shipped By:	your truck	Ship Date:	Jun 26, 2013	

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
02230-1 Mounting Lug Machine as per drawing for D2230 REV.G Batch#102280	Each	220	134	
he delivered goods must be inspected upon receipt to confirm compliance. hould there be discrepancies please notify METEC within 30 days of delivery. he goods are otherwise deemed accepted.				
Received by	Thank you for your order!			





20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0
Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

SHIPPED TO:

Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, Ont.

same

K6A 1K7

QUANTITY PART NUMBER

PART NAME

P.O. NUMBER

134

D2230-1

Lug

PO 20001

MATERIAL: supplied by DART B93551

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Jan Norris

Vankleek Hill, June 26, 2013

